

Work Order ID 73869

Friday, September 16, 2011 2:42:34 PM



Page 1

Item ID: D206-642-151

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 9/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-09-19 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3804	A
IIN-D206-642	O

100 0.00



DOCUMENT CONTROL

DC 0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-642-151 CHG001

N/A *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Debur Fwd edge of tube								
	2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804								
	3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required. Pick: Qty <input type="checkbox"/> Part Number <input type="checkbox"/> Description <input type="checkbox"/> Batch A/R <input type="checkbox"/> Aluminum Rod <input type="checkbox"/> M117884 BE 11/10/04								
	4-Grind weld flush to cap on top surface only. BE 11/10/04								
	5-Cut Aft end as per dwg D3804 from front of tube and Debur								
	6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804								
	7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.								
	8-Drill pilot holes using Dt8166 & DT8169D & DT9771.								
	9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes; cleco DT8732 & doubler leaving DT8732 for added support.								
	10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.								

> mo/DP

11-9-26

SAD 11-10-21 ①

SAD 11-10-25 ①

SAD 11-11-01 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Suluu

SAD
11-11-01 (1)

PO →

DC
11/11/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D726-642-151 PAR #: _____ Fault Category: Landing gear NCR: Yes ☒ No ☐ DQA: AK Date: 11/14/14
 Resolution: Re work Disposition: Re work QA: N/C Closed: ck Date: 11/12/15

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/10/14</u> <u>11/12/14</u>	<u>#100-11</u>	<u>Qty + 3 holes Drilled analyzed</u> <u>Due to passing through Aluminum</u> <u>mat. to standards</u> <u>R.C. Process</u>	<u>CP</u> <u>11.11.08</u> <u>CP/10/14</u>	<u>→ Fill affected holes with</u> <u>weld as per Q57004</u> <u>A/R <u>MIL7884</u></u>	<u>BE</u> <u>11-11-14</u> <u>BE</u> <u>11-11-14</u>	<u>DD</u> <u>11-11-15</u>	<u>CP</u> <u>11.11.08</u> <u>CP/10/14</u>	<u>S</u> <u>ululo7</u>
			<u>CP</u> <u>11.11.08</u>	<u>→ ReDrill as per Dwg.</u>	<u>DE</u> <u>11/11/15</u>	<u>DD</u> <u>11-11-15</u>	<u>CP</u> <u>11.11.08</u>	<u>S</u> <u>ululo7</u>

NOTE: Date & initial all entries

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Item Name: Replacement Skidtube

Start Date: 9/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160 Skidtubes Skidtubes	Skidtubes Memo 1-Open holes to finished size as per Dwg D3804, (without cutting fluid) 2-C'sink crossbolt spacer holes as per Dwg D3804 (without cutting fluid) 3-Deburr and blow out all chips from inside the tube	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 9/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

DP 11-11-16

180

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required DC 11/11/16

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12

Hrs. cure time before cutting

Start Date: 11/11/16 Time: 3:30

Finish Date: 11/11/17 Time: 9:30

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Sikaflex-291 ☐ 119399 ☐

Sikaflex expire date: 12/08/13 DC 11/11/16

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 9/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1	0	3E11-11-17	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00



Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐ 1117884

3-Grind welds flush as per Dwg D3804.

BB 11/11/22

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐ NONE BE 11-11-22

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

DP 11-11-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 HandFinish Hand Finishing	HandFinishing Memo Install D2680-041 Nut Plate as per Dwg D3804	0.00 0.00				1	33	11/4/22	
220 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
230 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

QC9 →

11.11.23

8/11/22

8/11/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BL 11-11-21

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:45
320°F
3:15

1XJ M/L 11/11/24

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

IRH & JL 11/11/24

M118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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270

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install
plugs as per Dwg D3804. Clean excess adhesive.

LRH / M u / u 29

280

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive
✓ A/R ☐ Sikaflex-291 ☐ M119443 ☐
Sikaflex expire date: ☐ 12/01

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4 ☐
Batch: M118988

LRH / M u / u 30

W/O:		WORK ORDER CHANGES					
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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

290

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11 12 01 ①

300

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 12 01 ①

310

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev:

PP 75681

11/12/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/14

MF
11-12-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 2:42:30 PM

Page 1

Work Order ID: 73869

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620		Manufactured	No			110	Each	12.0000	1	1			
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Skidtube, 206 Skidtube

Location	Loc Qty	Loc Code
LG	12	
68136	1	
71616	5	
71617	6	

D2647		Manufactured	No			110	Each	44.0000	1	1			
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Cap

Location	Loc Qty	Loc Code
LG002	44	
55352	14	
71171	30	

CR3212-4-04		Purchased	No			180	Each	1,655.000	52	52			
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Cherry Rivet

Location	Loc Qty	Loc Code
ST311	1655	
116471	78	
117816	477	
118686	100	
118840	1000	

119017

mo/ 11-9-26

BE 11/10/09

OK 11/11/16

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 2:42:30 PM

Work Order ID: 73869

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-1 Manufactured No

180 Each

6.0000

1 1



Web

75477



①

11/11/16

Location

Loc Qty

Loc Code

LG

6

64562

6

D3286-1 Manufactured No

180 Each

32.0000

2 2



Doubler



SAD

11-11-06

Location

Loc Qty

Loc Code

LG002

32

52844

11

64563

21

D2649 Manufactured No

200 Each

289.0000

19 19



Cross Bolt Spacer



37444

②

BE11-11-17
B 73855 *19

Location

Loc Qty

Loc Code

LG

6

68224

2

71355

2

72704

2

LG001

283

65317

1

68507

11

73390

271

D3286-3 Manufactured No

200 Each

27.0000

2 2



Spacer



BE11-11-22

Location

Loc Qty

Loc Code

LG002

27

64564

27

B 74870 *2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 2:42:31 PM

Work Order ID: 73869

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

210

Each

19.0000

1

1



Nut Plate



1

11/11/22

Location

73854

Loc Qty

Loc Code

ST020

19

55366

17

70088

2

CR3212-4-03

Purchased

No

210

Each

1,138.000

2

2



Cherry Rivet



2

11/11/22

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1136

114859

1136

AN960JD416

NAS1149D0463J

Purchased

No

210

Each

0.0000

1

1



Washer



1118384 (x1) 11/11/29

CCR264SS3-3

Purchased

No

210

Each

435.0000

2

2



Cherry Rivet



2

11/11/22

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

433

117086

23

117849

410

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 2:42:31 PM

Work Order ID: 73869



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

29.0000

1

1



1119075(v1) M 11/1/29

Screw

Location

Loc Qty

Loc Code

FP-A

8

115460

8

ST292

21

115460

21

D2651-1

Manufactured

No

270

Each

289.0000

6

6



373827(x6) M 11/1/29

Plug

Location

Loc Qty

Loc Code

fpa

109

69018

109

FP-A

180

57869

1

66445

10

67760

36

70691

100

70839

2

71037

31

D2651-3

Manufactured

No

270

Each

799.0000

6

6



M 11/1/29

O-Ring

Location

Loc Qty

Loc Code

FP-A

799

61962

12

66956

282

73489

505

V6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 2:42:31 PM

Work Order ID: 73869

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D3873-1 Manufactured No

280

Each

160.0000

14

14



Bushing



B75481(x14) MU ulul29

Location

Loc Qty

Loc Code

ST084

4

68247

4

ST088

156

64760

1

70690

54

71837

101

D2646 Manufactured No

280

Each

89.0000

1

1



Aft Cap



B73294(x1) MU ulul29

Location

Loc Qty

Loc Code

FP004

45

68280

45

FP006

5

62678

5

FP-4

35

70945

1

71070

34

fp5

4

71038

4

D3805-041 Manufactured No

280

Each

0.0000

1

1



Wearplate Assembly Fwd, Low Gear *



B76440(x1) MU ulul30
75490

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 2:42:31 PM

Work Order ID: 73869

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,296.000

2

2



Handwritten: 11/11/29

Screw

Location

Loc Qty

Loc Code

ST291

1296

115108

96

117423

300

118378

400

118910

500

Handwritten: X2

MS21042L3

Purchased

No

280

Each

1,603.000

7

7



Handwritten: 11/11/29

Nut

Location

Loc Qty

Loc Code

ST300

1603

117441

24

117601

374

117885

205

118451

1000

D3805-045

Manufactured

No

280

Each

6.0000

1

1



Handwritten: 11/11/29

Wearplate Assembly Aft, Low Gear

Location

Loc Qty

Loc Code

FP

6

70878

6

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2



Handwritten: 11/11/29

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Friday, September 16, 2011 2:42:31 PM

Work Order ID: 73869



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-37A

Purchased

No

280

Each

261.0000

7

7



Bolt



1119086 (x7) M 11/1/29

Location

Loc Qty

Loc Code

ST353

211

111668

111

118628

100

ST354

50

117619

50

NAS1149D0363J

Purchased

No

280

Each

2,623.000

7

7



Washer



1118968 (x7) M 11/1/29

Location

Loc Qty

Loc Code

ST298

2623

117601

308

118077

1315

118612

1000

Friday, September 16, 2011 2:42:31 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97		
DRAWN	97		
CHECKED	97		
MFG. APPR.	97		
APPROVED	97		
DE APPR.	97		
DATE	08.07.07		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3804
REV. A
SHEET 1 OF 5

TITLE SKIDTUBE ASSEMBLY, 206A/B
SCALE NTS

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RELEASED
08.07.07
per ECN 09-536

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

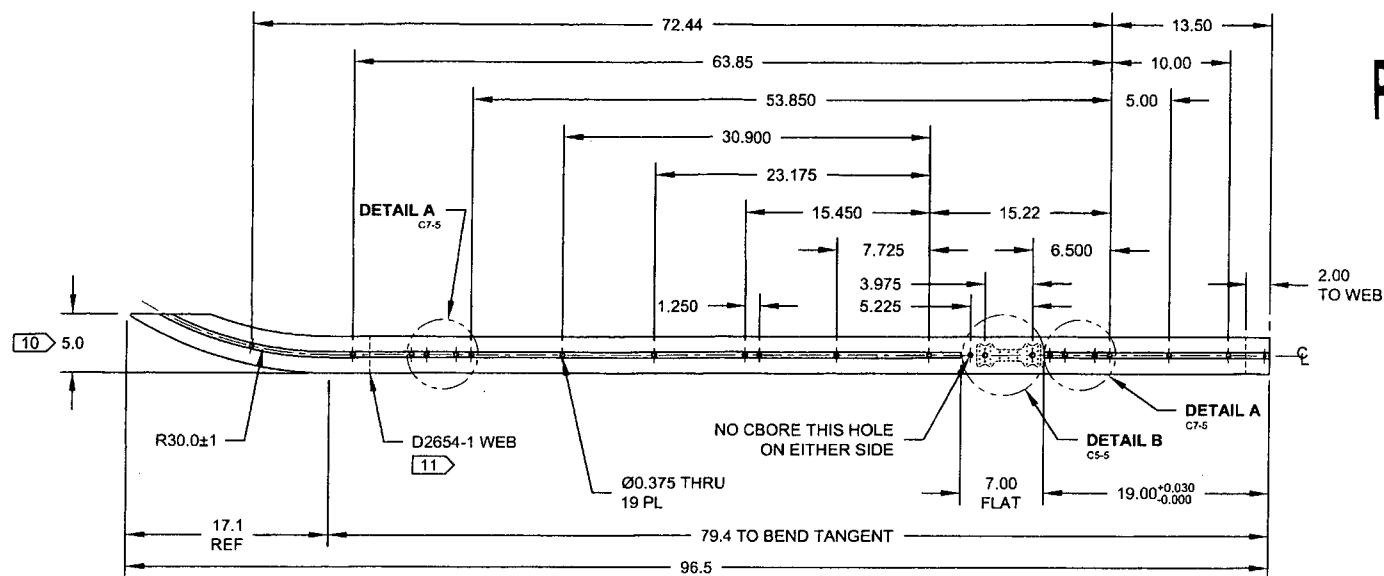
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

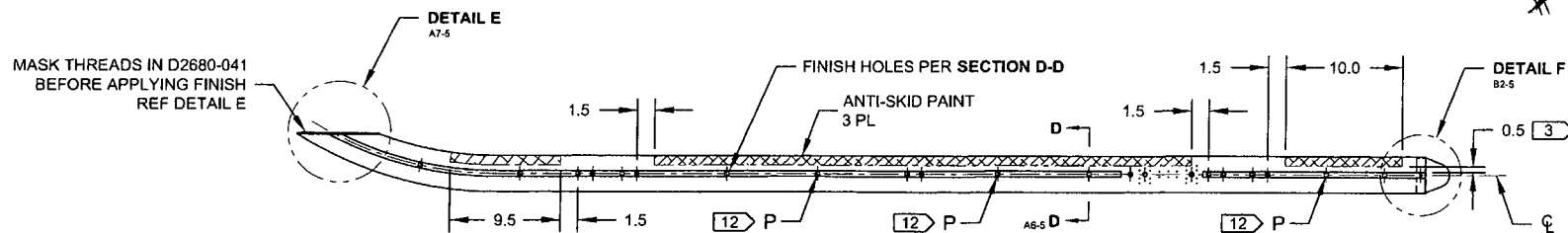
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
09.03.03



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 2 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

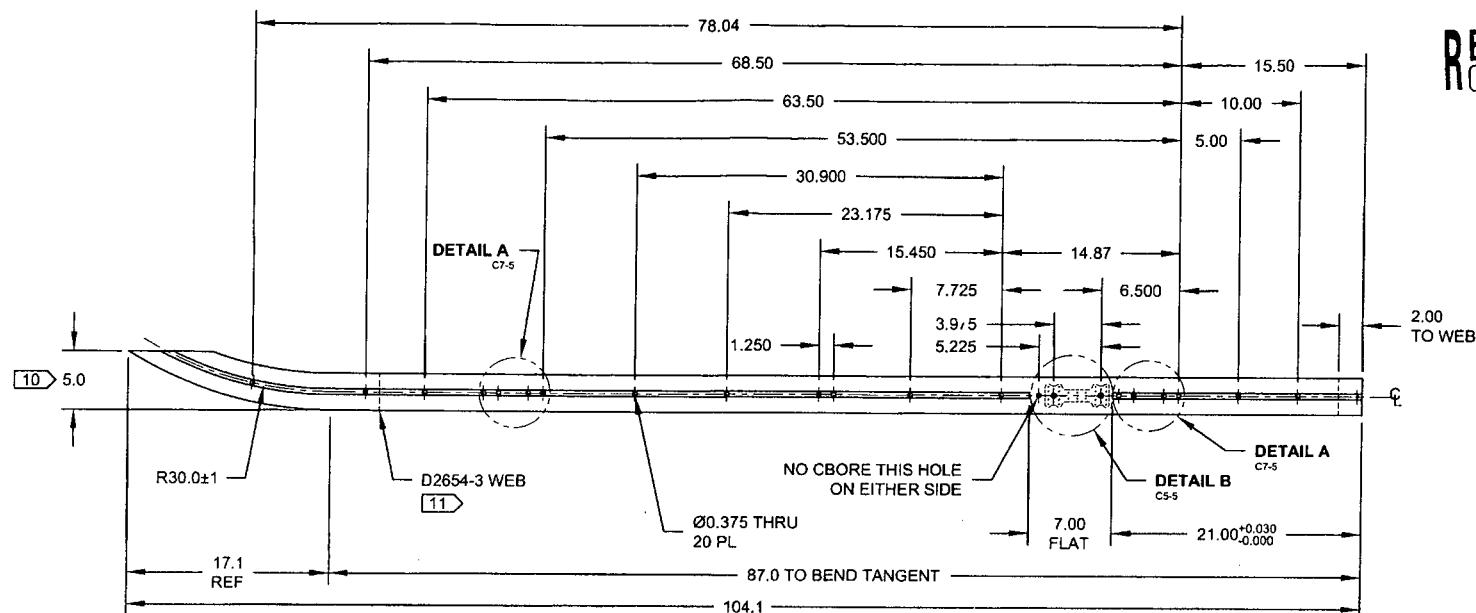
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

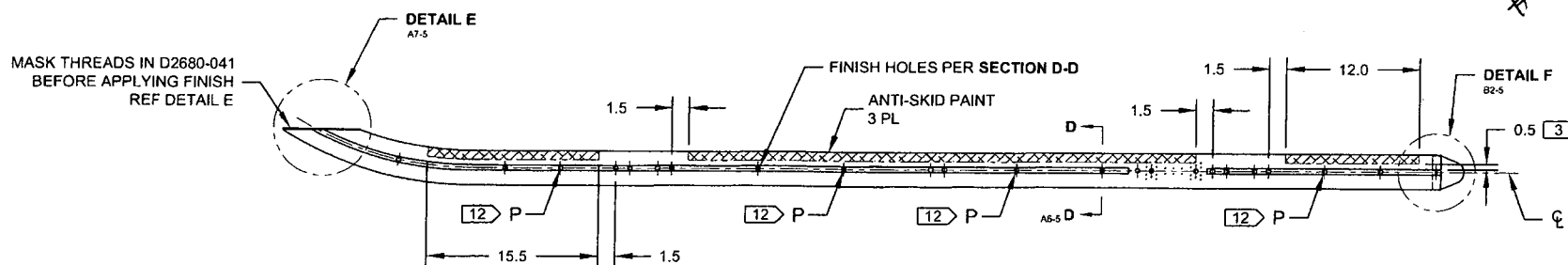
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
09-03-03



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NT
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

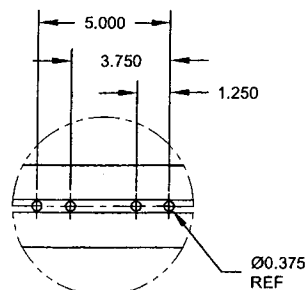
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

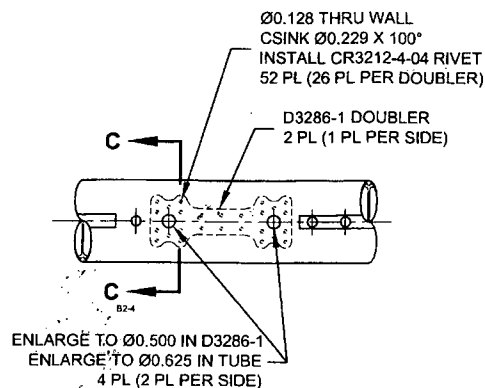
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
UP 09.03.03

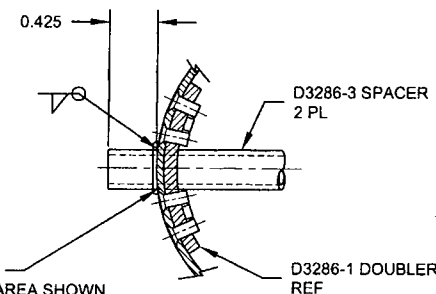


DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3

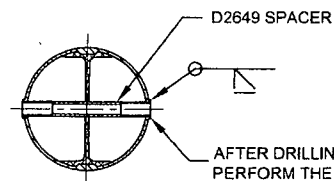


DETAIL B
SCALE NONE
C3-2
C3-3

- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH



SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



SECTION D-D A4-2
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-3

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 4 OF 5
APPROVED	91	TITLE	SCALE
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
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73869

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07.07.07

CCR264SS3-3
RIVET
2 PL

CR3212-4-03 RIVET
2 PL

VIEW G-G
SCALE NONE
A7-5

D2647 CAP, TO INSTALL:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS REQD)
4. WELD D2647 IN PLACE
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE
IN PLACE

MS27039-4-06 SCREW
AN960JD416 WASHER

D2680-041
NUTPLATE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

07.5 G

1/16

DETAIL E
SCALE NONE
B7-2
B7-3

0.400

END OF WEB

SEAL WITH
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204
REF

MS27039-1-08 SCREW
AN960JD10L WASHER
2 PL

BORE OUT END
OF SKIDTUBE
TO 0.75 DEPTH
AND 0.070 WALL

DETAIL F
SCALE NONE
B2-2
B2-3

73869

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 5 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Chris Provencal

From: David Shepherd <dshepherd@dartaero.com>
Sent: Thursday, November 10, 2011 3:35 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Eric Downing'
Subject: RE: NCR D3804

Chris,

Sorry for the delay ... As long as it's only 1 or 2 holes per spacer location, I agree it is OK to fill with weld and re-drill.

David

From: Chris Provencal [<mailto:cprovencal@dartaero.com>]
Sent: November-07-11 9:09 AM
To: David Shepherd
Cc: Mike Petsche; 'Eric Downing'
Subject: NCR D3804

David,

For the 206A/B skid tubes, the rivet holes for the GHW doubler (detail B, pg 4 of D3804) are frequently being ovalized or enlarged. Because they are doing the holes by hand, it is easy for the drill to pull occasionally.

Is it acceptable to fill with weld and re-drill? I've been told that we've done this in the past. My only concern is creating too large a heat affected zone, so if it is only one or two rivets near each spacer, then it would be acceptable in my opinion. For holes that are slightly enlarged, my recommendation to them has been to leave it as is, as the rivet will mostly bear on the countersink anyway.

-Chris

NO. 274

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 75391
Part number: D206 642 151
Description: D206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Sal Lum Date of Test Coupon 11-11-18

Welder Barclay Elliott Date of Test Coupon 11-11-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld